

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021754**Date Inspected:** 11-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Lv Li Qing /Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing:-

BAY#14

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as 14W Bottom panel stiffener to Floor Beam. The weld designation reviewed is as follows:

SEG3020M-080, 138, 144, 150, 156, 162, 168, 174, 180

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as 13AE Bottom panel stiffener to Floor Beam. The weld designation reviewed is as follows:

SEG3007R-164,135,139,143,147

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In process Inspection:-

BAY#14

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG3019BB-078 located on OBG Segment 14E Bottom Panel Stiffener to Floor beam. Welder is identified as #037997. ZPMC QC is identified as Mr. Zhang Qiang. Welding was performed according to the weld repair report B-WR20246. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1.

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG Segment 14E Floor Beam. The weld joint was designated as: SEG3019-1-105. The welder is identified as #201087. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC appear to comply with WPS-B-P-2212-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 14E Floor Beam to Side panel. The weld joint was designated as: SEG3019C-002. The welders are identified as #070007 and 066163. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Segment 14E Longitudinal Diaphragm stiffener to Floor Beam. The weld joint was designated as: SEG3019Z-16. The welder is identified as #066763. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2231-ESAB. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 14E Side panel stiffener. The weld joint was designated as: SEG3019B-029. The welder is identified as #066733. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13AE Side panel stiffener. The weld joint was designated as: SEG3007E-207. The welder is identified as #067877. ZPMC CWI is identified as Mr. Liu Hui Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 13AE Deck panel to Edge panel. The weld joint was designated as: SEG3007AB-094. The welder is identified as #067656. ZPMC CWI is identified as Mr. Liu Hui Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4B-FCM-1.

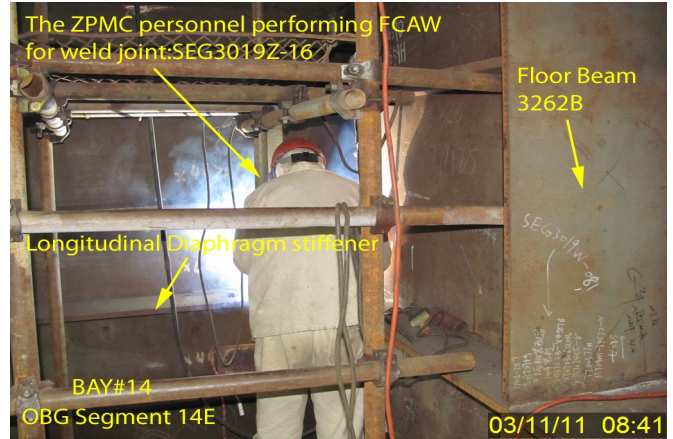
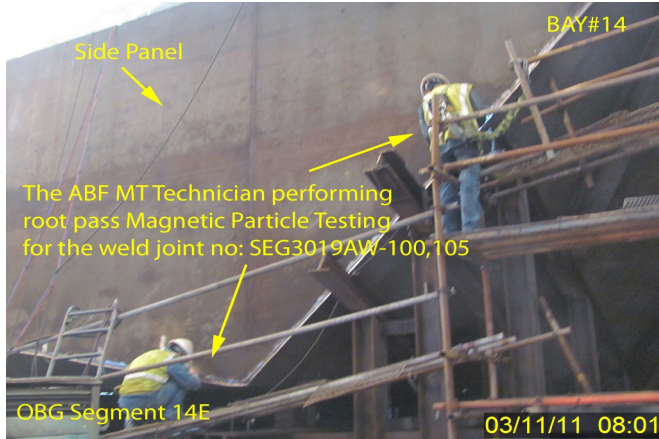
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No Relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai, Pandaram

Quality Assurance Inspector

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**Reviewed By:** Patel, Hiranch

QA Reviewer